

# Work Order ID 64111

Wednesday, November 24, 2010 1:14:57 PM



Page 1

Item ID:	D3929-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gusset Assembly					
Start Date:	11/24/2010	Start Qty:	6.00			
Required Date:	11/30/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								
100		0.00							
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	1-Cut as per Dwg D3929								
	Dwg Rev: A								
	Prog Rev: A								
	2-Deburr if necessary								
110		0.00							
QC									
Quality Control									
	Memo	0.00							
	QC2- Inspect parts off machine FAI/FAIB								

B 10-11-25

7

B 10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64111**

Wednesday, November 24, 2010 1:14:57 PM

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Item ID: D3929-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset Assembly

Start Date: 11/24/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 4114649

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



S101026

47

10/12/01 (7)

10.12.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 64111**

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Item ID: D3929-042

Accept

Revision ID:

Item Name: Gusset Assembly

Start Date: 11/24/2010 Start Qty: 6.00

Required Date: 11/30/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
StopSequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

10/12/02

27

1042

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Basket coll

Memo

Packaging

0.00

10/12/01

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

10/12/03  
MF  
10-12-02

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, November 24, 2010 1:15:03 PM

Page 1

Work Order ID: 64111

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	34.7523	0.45	2.842105			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		34.7523				114794			
				114799		34.7523							
D3907-1  Bushing		Manufactured	No			130	Each	49.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		49							
				60720		5				5x			
				62149		4				4x			
				63561		40				2x 5x			

1810-11-25

⑦

10/10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

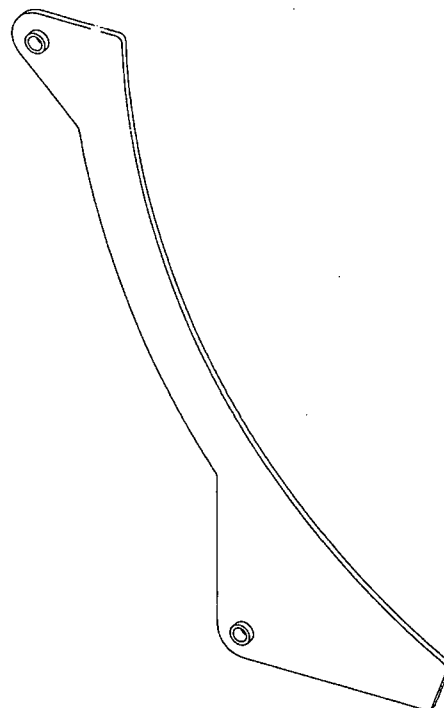
**NOTE:** Date & initial all entries



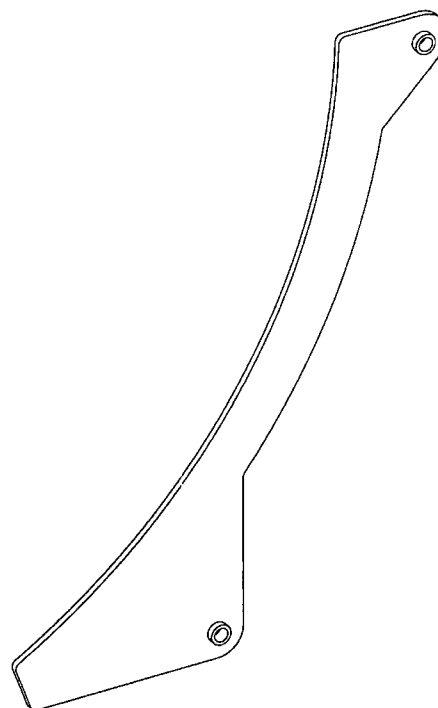


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4411  
BS10-11-24

**RELEASED**  
37642 MD

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO. D3929		SHEET 1 OF 3
TITLE GUSSET ASSEMBLY		SCALE NTS
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8 7 6 5 4 3 2 1

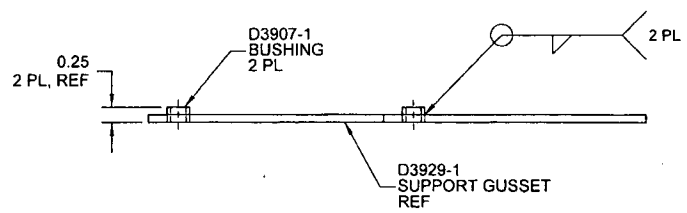
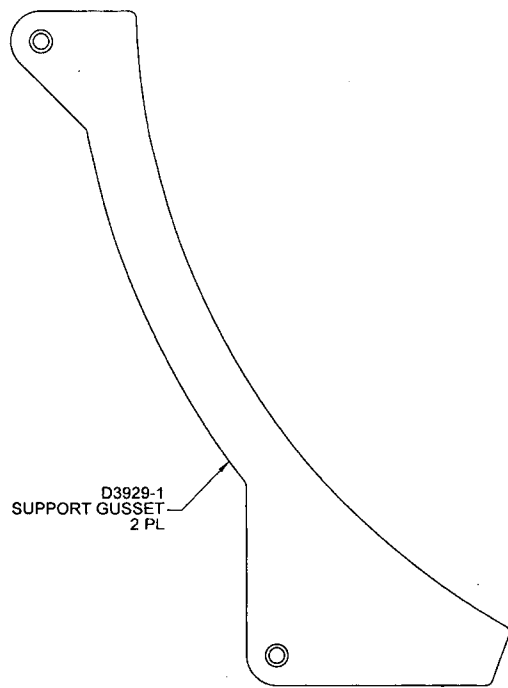
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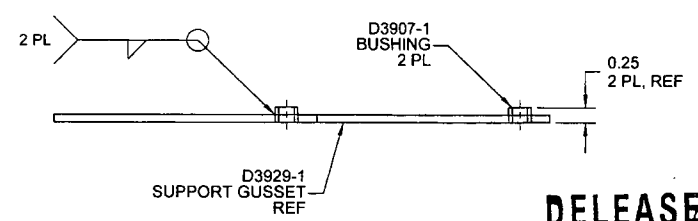
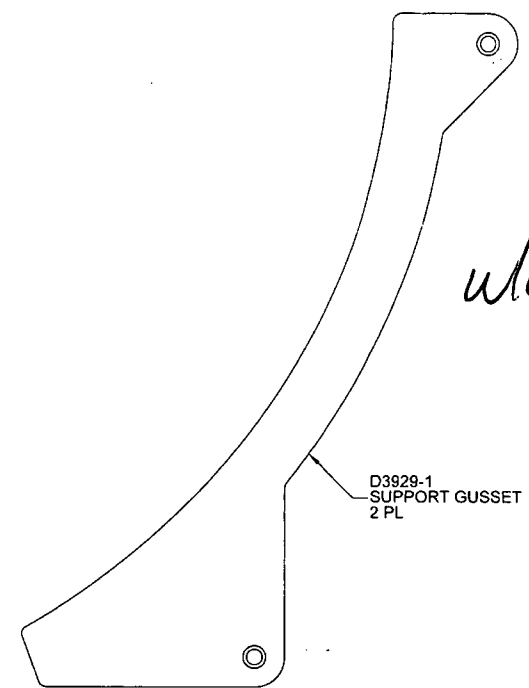
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3929-041 GUSSET ASSEMBLY**



**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
09/04/22

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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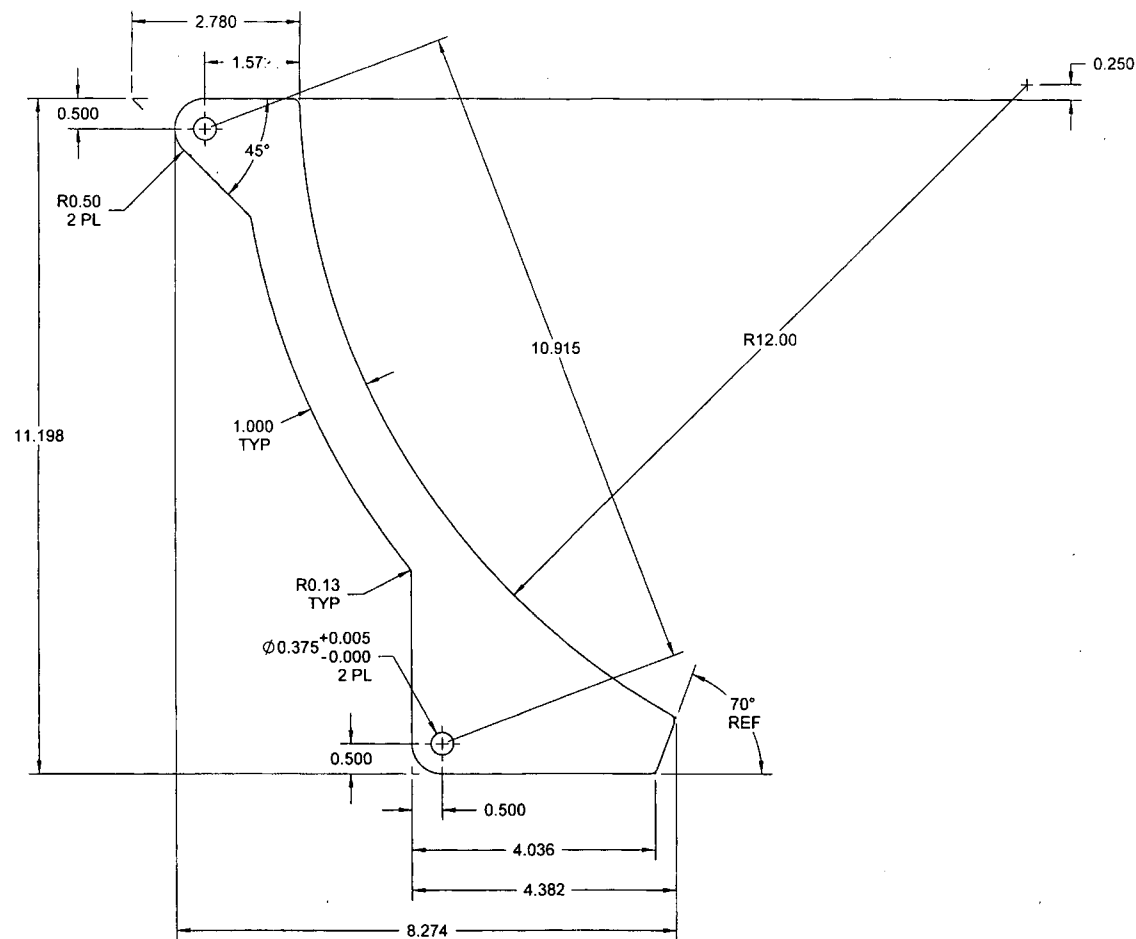
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**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

**RELEASED**  
09/04/2003

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3929</b>	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>GUSSET ASSEMBLY</b>	SCALE
DE APPR.			NTS
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